

Date: Monday, 07/07/2008 4:18:22 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 02.250 SUPPORT
 Job Number : 40336
 Estimate Number : 11057
 P.O. Number :
 This Issue : 07/07/2008 S.O. No. :
 Prsht Rev. : NC Drawing Number : D2891 REV A1
 First Issue : / / Project Number : N/A
 Previous Run : 39060 Type : PURCHASED PARTS Drawing Revision : A1
 Written By :
 Checked & Approved By : JL 08.7.07
 Comment : Est. C 02.11.26 Added P/O KJ
 Est D 08.03.19 Re-format EC verified: DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DSK076 D2891-1 TURNING DETAIL



Comment: Qty.: 0.5000 Each(s)/Unit Total : 10.0000 Each(s)
 D2891-1 TURNING DETAIL
 Batch: 39065

JL 08/08/06

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS
 Machine as per Folio FA046
 Tumble & Deburr

HA 08/08/07 JL 08/08/06

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HA 08/08/07

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

HA 08/08/09

5.0 POWDER COATING POWDER COATING



M 108523



(20X)

Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00
400 OF
10:30

M 108523 08/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/07/2008 4:18:22 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 40336

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F/L 08/08/20 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 08 21

(20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



mk 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40330
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193	0.19	0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.249	0.249	0.248	0.248	0.249
AC	0.115	0.150		0.127	0.127	0.128	0.128	0.129
AD	0.040	0.060		0.0505	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.019	0.019	0.017	0.017	0.017
AF	0.240	0.260		R 0.250	R 0.250	R 0.250	R 0.250	R 0.250
AG	0.290	0.310		0.309	0.309	0.309	0.309	0.309
AH	0.115	0.150		0.140	0.140	0.142	0.142	0.141
AI	0.454	0.474		0.464	0.464	0.466	0.463	0.474
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AL	1.002	1.042		1.042	1.029	1.041	1.034	1.038
AM	0.053	0.073		R.063	R.063	R 0.063	R 0.063	R 0.063
AN	0.257	0.262		0.260	0.260	0.260	0.260	0.260
AO	1.663	1.683		1.674	1.674	1.665	1.666	1.675
AP	0.053	0.073		R.0.063	R 0.063	R 0.063	R 0.063	R 0.063
AQ	0.022	0.042		R 0.032	R 0.032	R 0.032	R 0.032	R 0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: B.A. 08/08/07 Date:

Audited by: SF 08/08/09 Date:

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 40336
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.249	0.249	0.249	0.249	0.248
AC	0.115	0.150		0.129	0.128	0.128	0.128	0.128
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.017	0.014	0.014	0.014	0.014
AF	0.240	0.260		R0.250	R0.250	R.250	R.250	R.250
AG	0.290	0.310		0.310	0.309	0.309	0.309	0.309
AH	0.115	0.150		0.141	0.141	0.142	0.140	0.140
AI	0.454	0.474		0.474	0.474	0.474	0.465	0.466
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AL	1.002	1.042		1.036	1.036	1.042	1.041	1.033
AM	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R0.063
AN	0.257	0.262		0.260	0.260	0.260	0.260	0.260
AO	1.663	1.683		1.675	1.675	1.675	1.676	1.673
AP	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R0.063
AQ	0.022	0.042		R0.032	R0.032	R0.032	R0.032	R0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: M.A. 08/08/07 Date:

Audited by: J.S. 08/08/07 Date:

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 403310
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.188	0.193	<i>OK</i>	0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.249	0.249	0.249	0.249	0.249
AC	0.115	0.150		0.129	0.129	0.129	0.129	0.129
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.014	0.014	0.014	0.014	0.014
AF	0.240	0.260		R0.250	R0.250	R.250	R.250	R.250
AG	0.290	0.310		0.309	0.309	0.309	0.309	0.309
AH	0.115	0.150		0.141	0.141	0.141	0.141	0.141
AI	0.454	0.474		0.465	0.465	0.465	0.465	0.465
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AL	1.002	1.042		1.032	1.042	1.042	1.035	1.039
AM	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R0.063
AN	0.257	0.262		0.260	0.260	0.260	0.260	0.260
AO	1.663	1.683		1.675	1.675	1.677	1.677	1.674
AP	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R0.063
AQ	0.022	0.042		R0.032	R0.032	R0.032	R0.032	R0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: *H.A* 08/08/07 Date: _____

Audited by: *S.D* 08/08/07 Date: _____

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 40336
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	#17	#18	#19	#20
HAAS Section								
AA	0.188	0.193		0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.249	0.249	0.249	0.249	0.249
AC	0.115	0.150		0.129	0.129	0.129	0.129	0.129
AD	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.014	0.014	0.014	0.014	0.014
AF	0.240	0.260		R0.250	R0.250	R0.250	R0.250	R0.250
AG	0.290	0.310		0.309	0.309	0.309	0.309	0.309
AH	0.115	0.150		0.141	0.141	0.141	0.141	0.141
AI	0.454	0.474		0.466	0.465	0.465	0.467	0.467
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		R.250	R.250	R.250	R.250	R.250
AL	1.002	1.042		1.034	1.042	1.042	1.035	1.040
AM	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R0.063
AN	0.257	0.262		0.260	0.260	0.260	0.260	0.260
AO	1.663	1.683		1.674	1.673	1.673	1.675	1.675
AP	0.053	0.073		R0.063	R0.063	R0.063	R0.063	R0.063
AQ	0.022	0.042		R0.032	R0.032	R0.032	R0.032	R0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: K.A. 08/08/07 Date: _____

Audited by: [Signature] 08/08/08 Date: _____

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	[Signature]

220 218 216 214

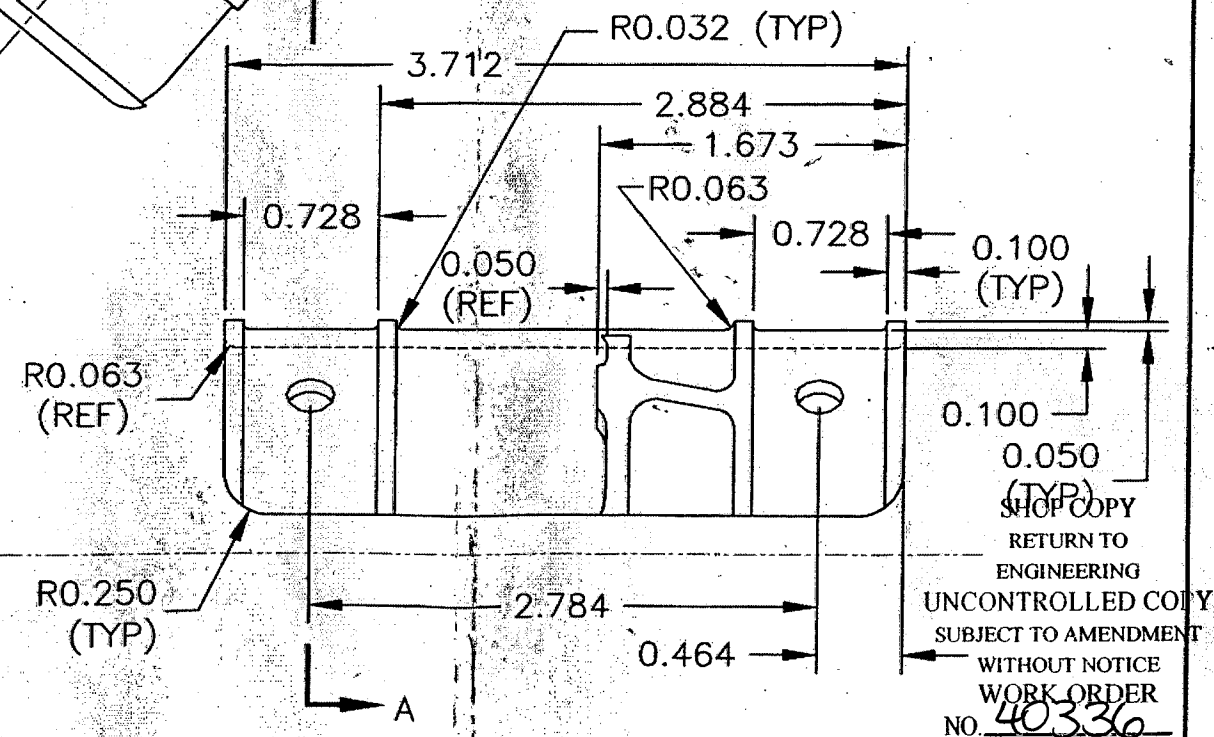
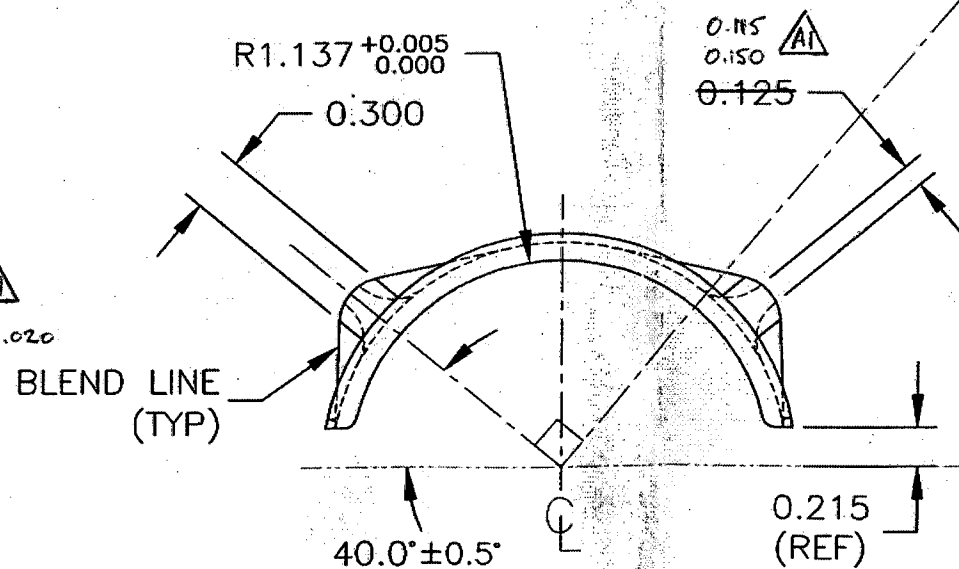
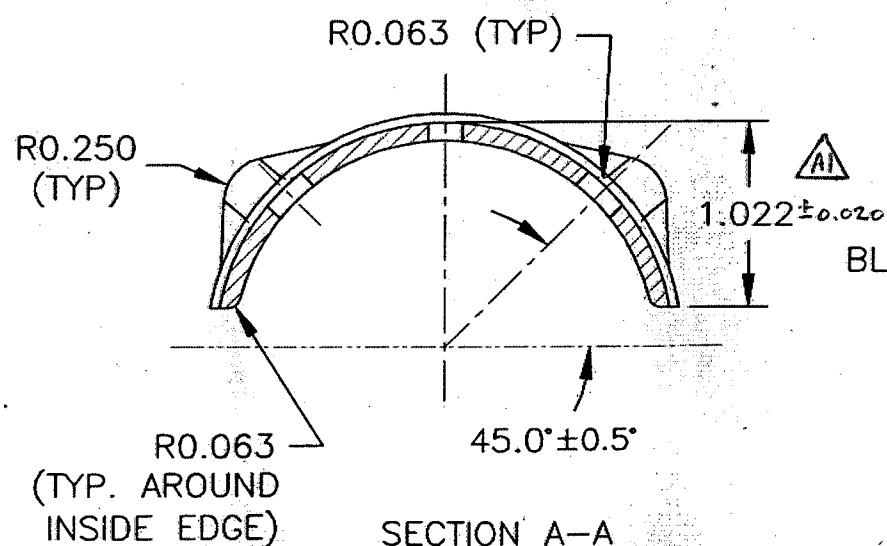
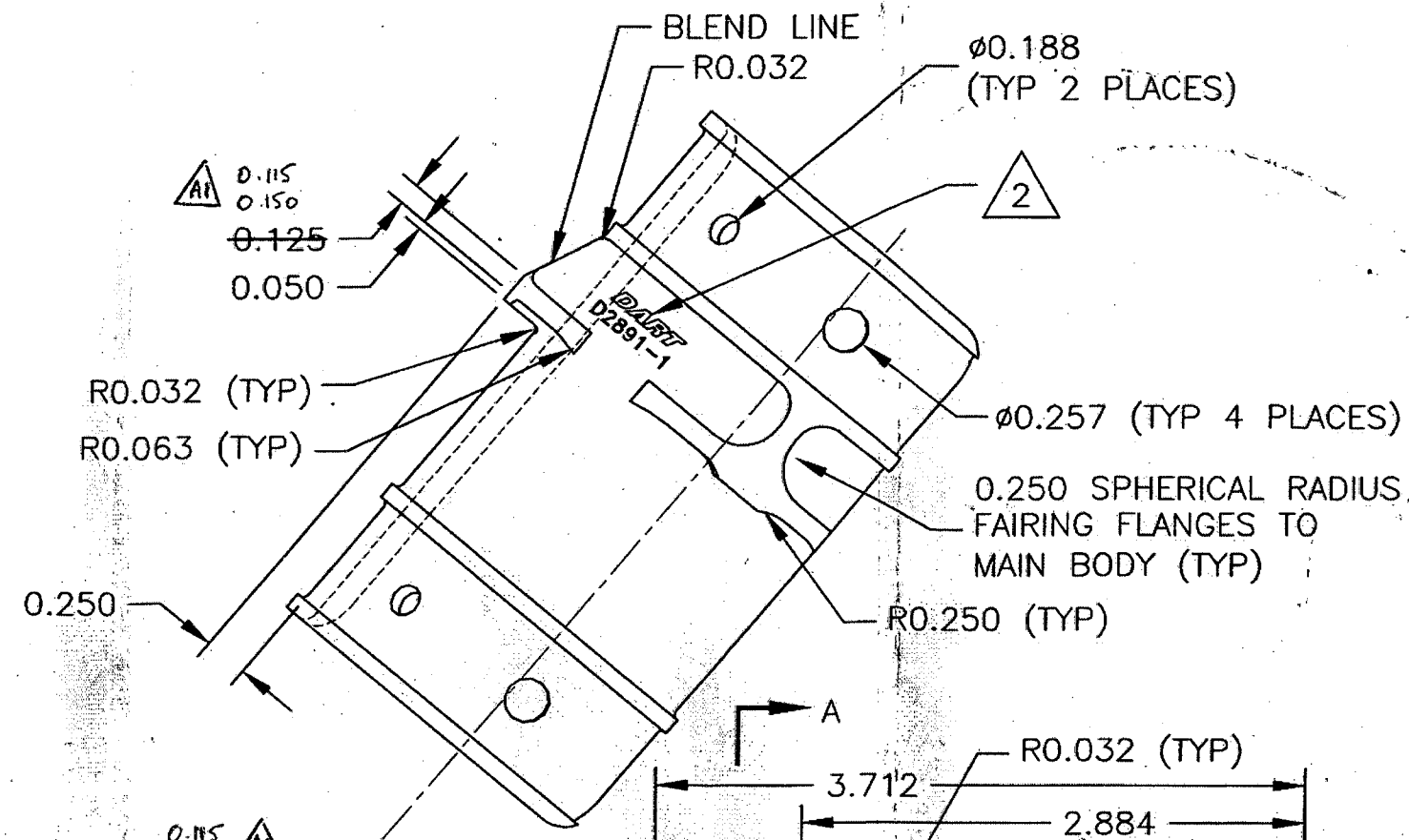
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111 110 109 108 107 106 105 104 103 102 101 100 99 98 97 96 95 94 93 92 91 90 89 88 87 86 85 84 83 82 81 80 79 78 77 76 75 74 73 72 71 70 69 68 67 66 65 64 63 62 61 60 59 58 57 56 55 54 53 52 51 50 49 48 47 46 45 44 43 42 41 40 39 38 37 36 35 34 33 32 31 30 29 28 27 26 25 24 23 22 21 20 19 18 17 16 15 14 13 12 11 10 9 8 7 6 5 4 3 2 1 0

215 214 213 212 211 210 209 208 207 206 205 204 203 202 201 200 199 198 197 196 195 194 193 192 191 190 189 188 187 186 185 184 183 182 181 180 179 178 177 176 175 174 173 172 171 170 169 168 167 166 165 164 163 162 161 160 159 158 157 156 155 154 153 152 151 150 149 148 147 146 145 144 143 142 141 140 139 138 137 136 135 134 133 132 131 130 129 128 127 126 125 124 123 122 121 120 119 118 117 116 115 114 113 112 111 110 109 108 107 106 105 104 103 102 101 100 99 98 97 96 95 94 93 92 91 90 89 88 87 86 85 84 83 82 81 80 79 78 77 76 75 74 73 72 71 70 69 68 67 66 65 64 63 62 61 60 59 58 57 56 55 54 53 52 51 50 49 48 47 46 45 44 43 42 41 40 39 38 37 36 35 34 33 32 31 30 29 28 27 26 25 24 23 22 21 20 19 18 17 16 15 14 13 12 11 10 9 8 7 6 5 4 3 2 1 0

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER NO. 40336

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DESIGN	CP	02.01.23	UPDATE DIMS AS MANUFACTURED
CHECKED	CP	00.11.17	NEW ISSUE
DATE	00.11.17		
DRAWN BY	CP		
APPROVED	CP		
DRAWING NO.	D2891		
TITLE	Ø2.250 SUPPORT		
REV. A			
SHEET 1 OF 1			
SCALE	1:1		



DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

